

Date: Tuesday, 12/2008 10:51:47 AM
 User: Julie Lecor

Process Sheet

Customer: U-DAR001 Dart Helicopters Services

Drawing Name : 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number : 40507

Estimate Number : 10257

P.O. Number

Part Number : D212664201

This Issue : 15/07/2008 S.O. No. :

Drawing Number : D212-664-241 REV C

Prsht Rev. : NC

Project Number : N/A

First Issue : / /

Type : CROSSTUBES

Drawing Revision : C

Previous Run : 40178

Material :
Due Date : 05/08/2008

Qty: 1 Um: Each

Written By :

Checked & Approved By :

JUL 08 15.08

Comment

Est Rev:E 04.02.16 Reformat K/DS
 Est Rev:F 06-03-29 Remove Comments on Pick List JLM
 Est Rev:G 07-04-30 As per Rev C JLM
 Est Rev:H 08-05-22 up date Qty of rubber cushion DD verified by:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-201CHG003

S0868607

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3.0

D212664201TRN

Crosstube Turning Detail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch B40339

EL 8-7-30

4.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-241 using CNC bender program 212-af and Folio FT007

EL 8-7-30

5.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

CP 08.07.30

32

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 Est Rev:H 08-05-22 up date Qty of rubber cushion DD verified by:EC

REFERENCE ONLY

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JUL 08 08.07



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-201CHG003

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3.0 D212664201TRN Crosstube Turning Detail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch _____

4.0 BENDING BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-241 using CNC bender program 212-af and Folio FT007

5.0 QC15 DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>J</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D212-664-241	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE CROSSTUBE ASS'Y (205/212 HI AFT) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

RELEASED
07.04.24
PER E.A.N. 0289

Qty	Part Number	Description
X	D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
1	D6006-129	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
4	MS21920-28	CLAMP (OR MS21920-30)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

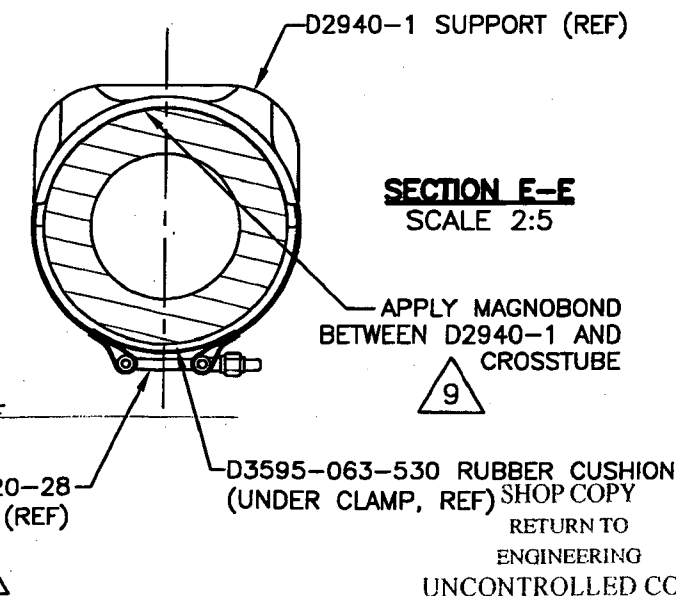
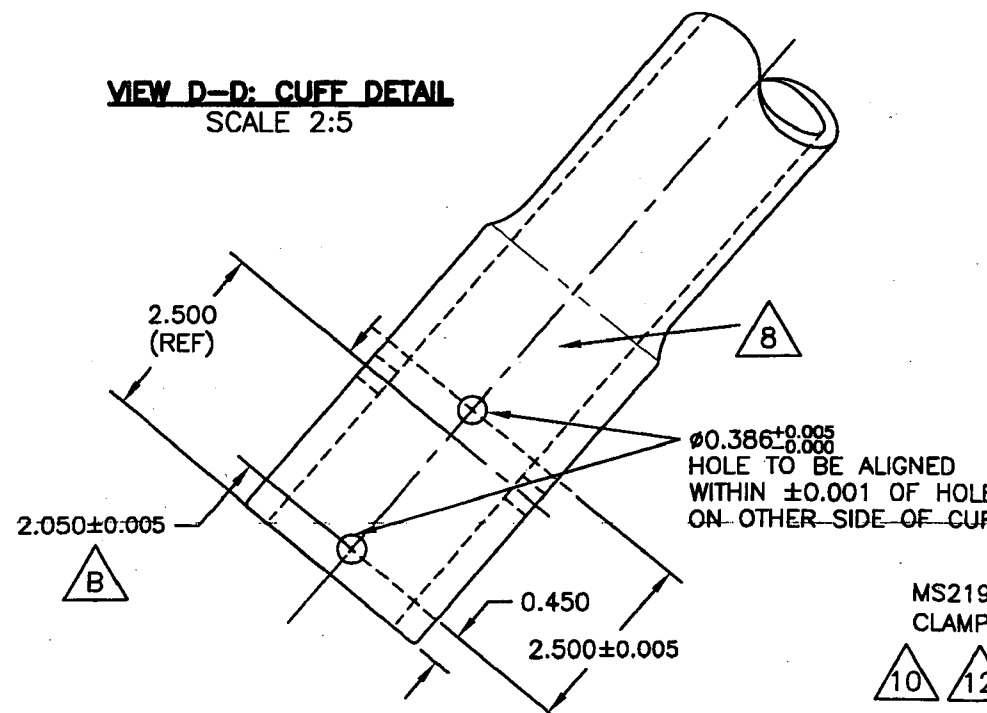
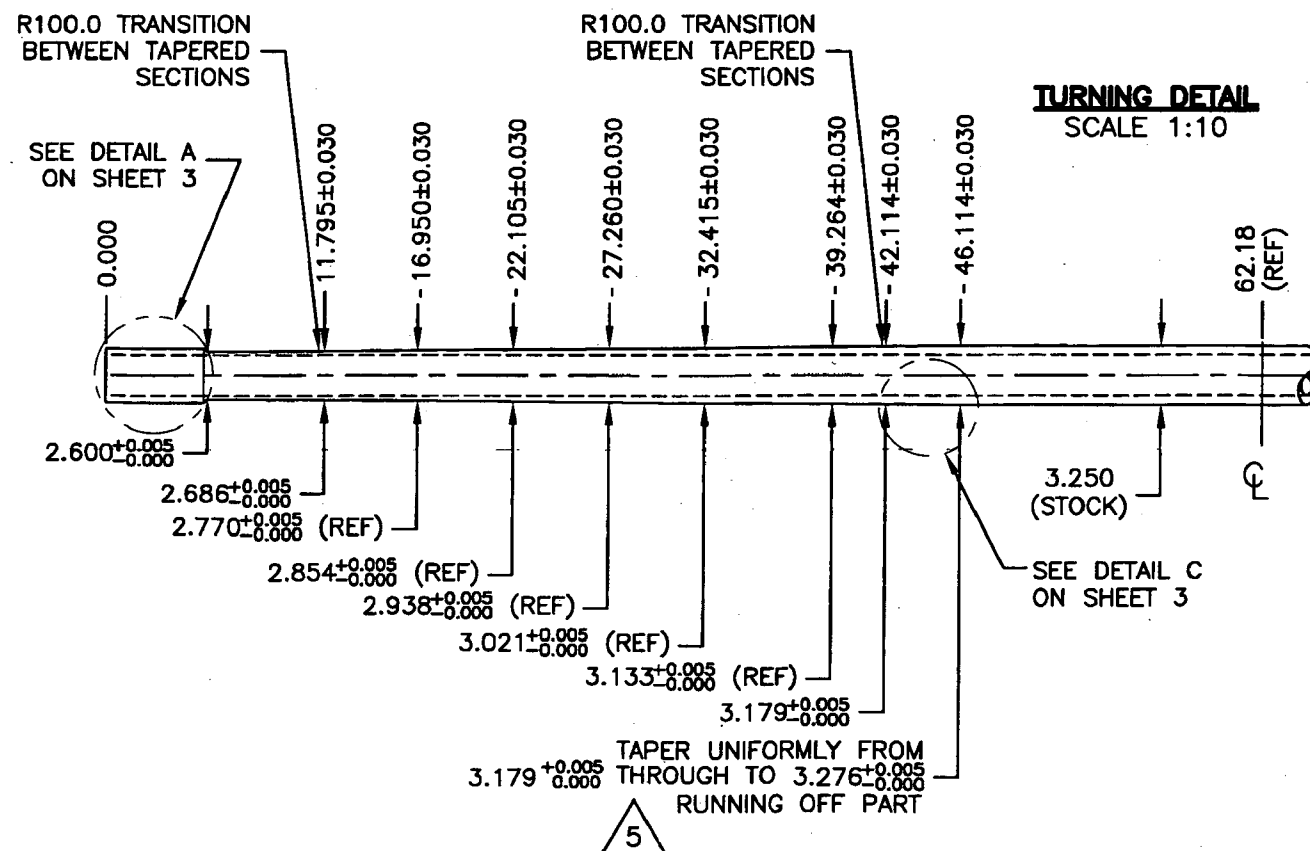
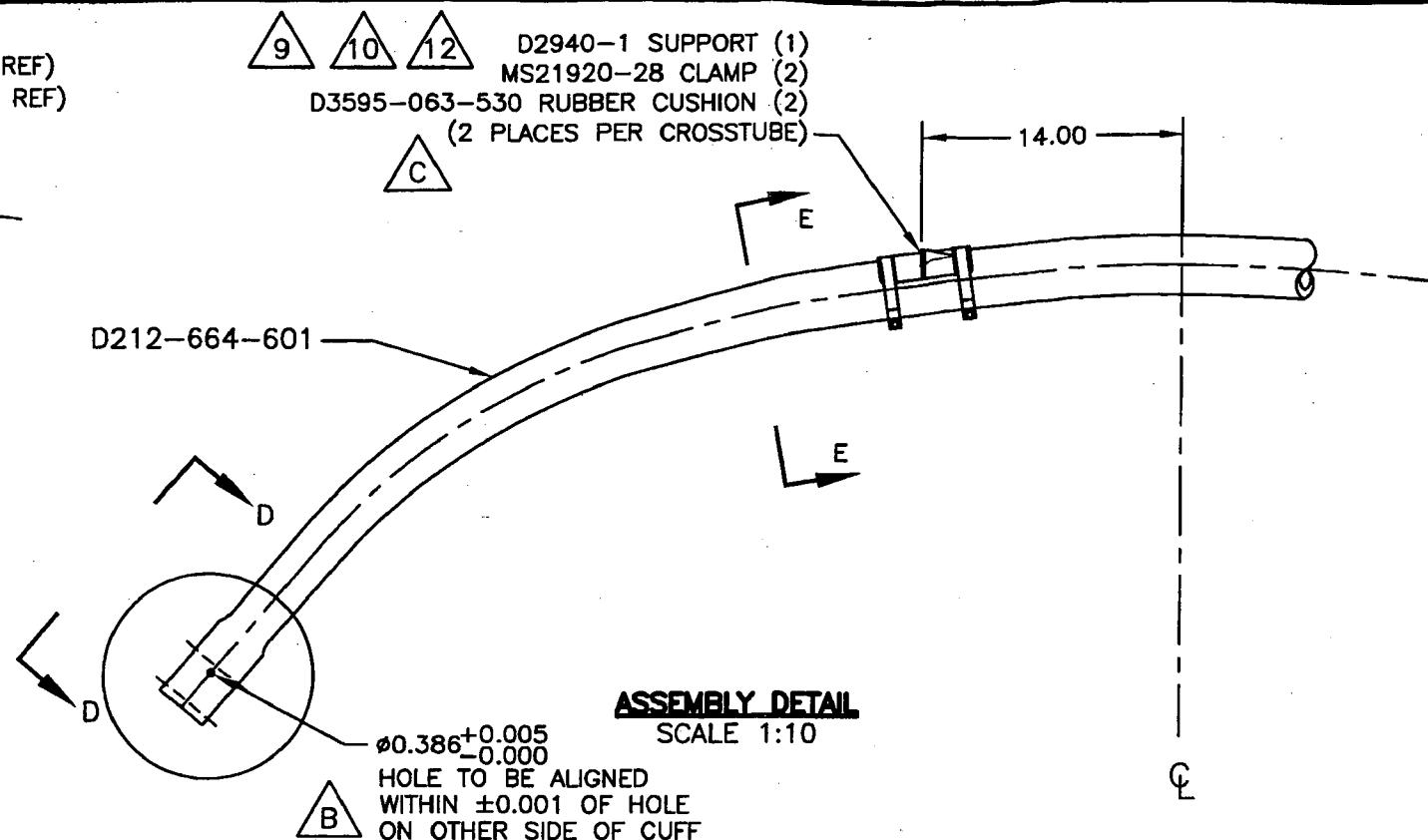
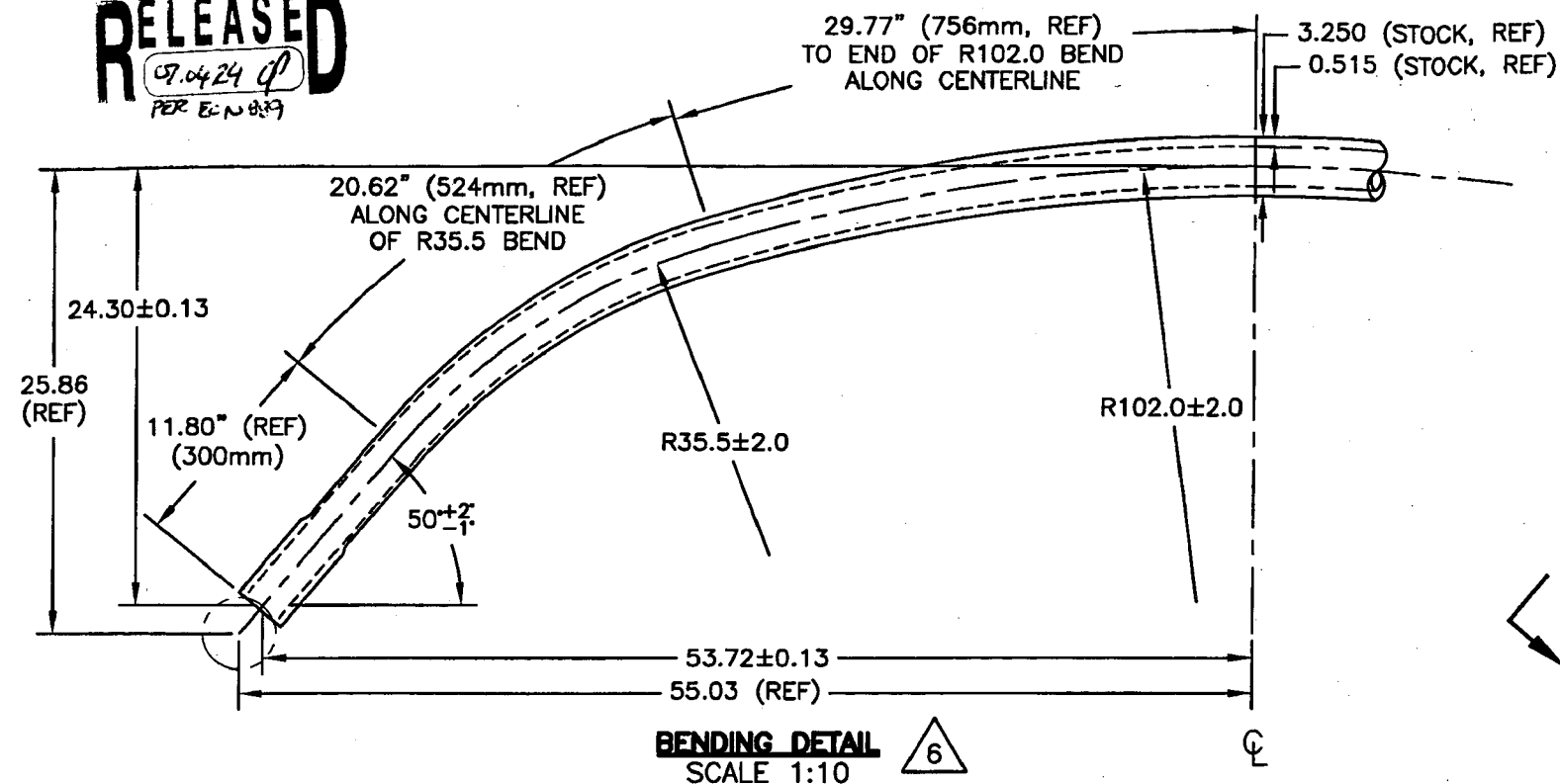
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.36±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 SUPPORT ON TOP SIDE OF CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT
NOTE: MS21920-30 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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RELEASED
07.04.24
PER E.N. 8.19

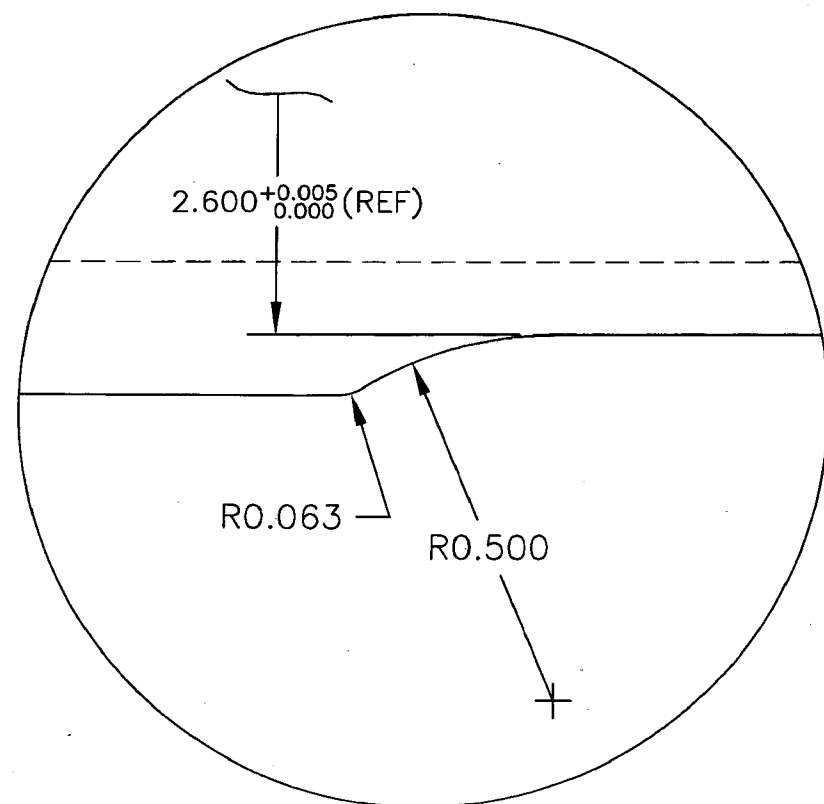
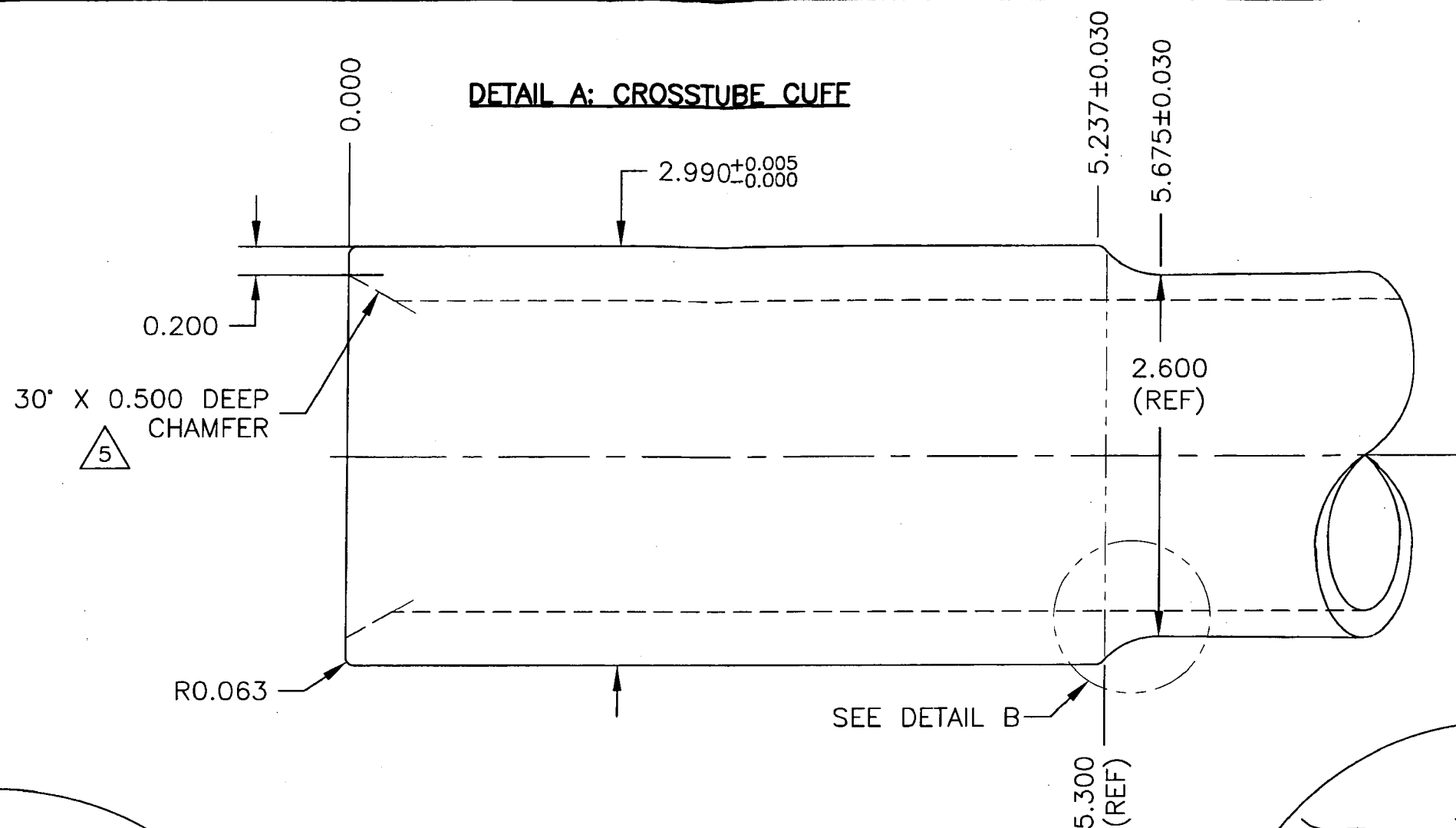


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DATE 07.03.08		TITLE CROSSTUBE ASS'Y (205/212 HI AFT)		SCALE 1:10	

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40507

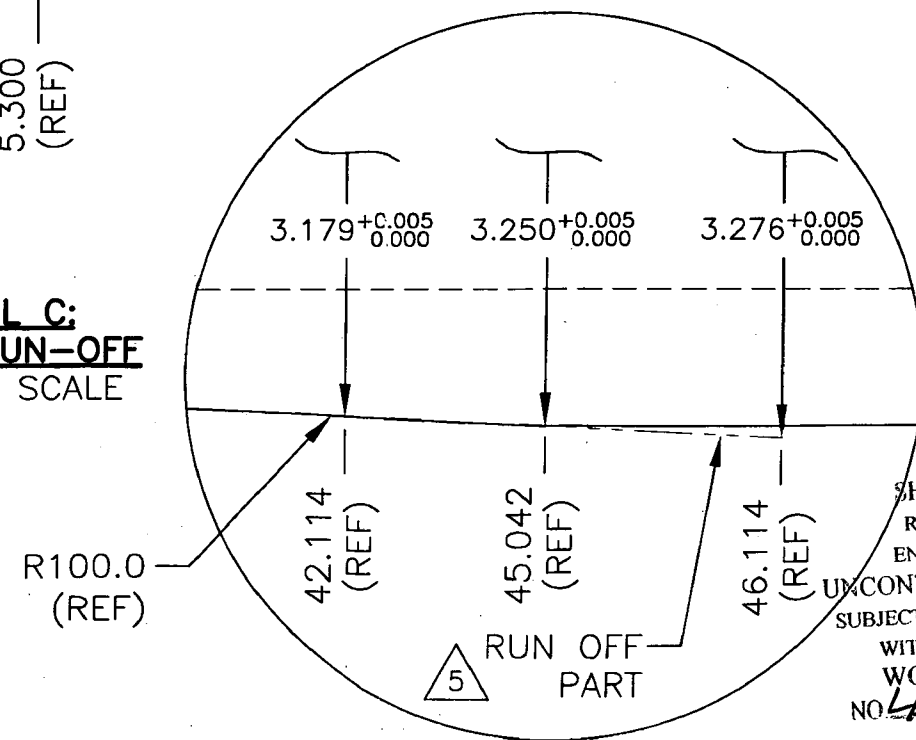
RELEASED
07.04.24
PER ECN 889

DETAIL A: CROSSTUBE CUFF



**DETAIL B: CUFF
TRANSITION
SCALE 4:1**

**DETAIL C:
TAPER RUN-OFF
NOT TO SCALE**



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DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED A	APPROVED JH	DRAWING NO. D212-664-241	REV. C SHEET 3 OF 3
DATE 07.03.08	TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE 1:1	

